

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019975**Date Inspected:** 05-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** SHANGHAI CHINA**CWI Name:** Mr.Chen xi.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)BAY 1 ~4**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

**BAY #3**

Flux Cored Arc Welding (FCAW) of welds joint FB3273-001-005, And Welder is identified as 206623, ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables appeared to comply with the Applicable WPS-B-T-2232TC-U4b-F.

FCAW of welds joint FB3273-001-056, And Welder is identified as 055564, ZPMC Quality Control (QC) is identified as Mr. Zhan Hai Feng. The welding variables appeared to comply with the Applicable WPS-B-T-2232TC-U4b-F.

**BAY # 2**

FCAW welding of welds joint VP3014-001-030, And Critical Welding Repair Report (CWR) B-CWR1980, and Welder is identified as 045276,045240; ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

variables appeared to comply with the Applicable WPS-345-FCAW-2G (2F)-FCM-Repair-1.

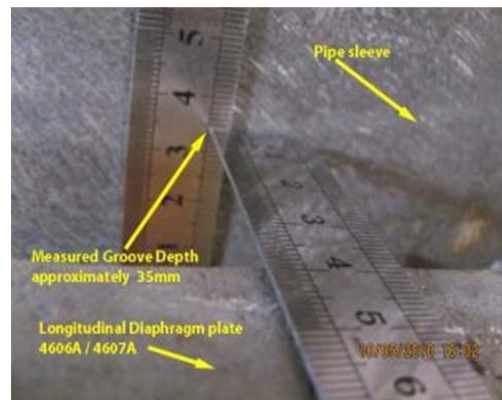
## BAY # 3:-

During the Quality Assurance In-process observations of Fabrication of OBG Floor Beam (FB) FB3286A, this Quality Assurance Inspector (QA) discovered the following issue:

- ZPMC personnel did not prepare the groove bevel per the approved Weld Detail (WD481K).
- The weld is a complete joint penetration (CJP) weld T-joint.
- These CJP's join Diaphragm Plates (X4606A, X4607A) to Pipe Sleeves (X8005A/B, X8006A/B) utilizing joint detail WD481K.
- These weld joints are identified as FB3286-001-015,016.
- The depth of the groove from face 'A' was approximately 35mm.
- The plate thickness is 50mm and is designated at Non Seismic Performance Critical Members (Non SPCM).
- FB3286A is currently located in Sub Assembly Bay # 3.

For further information, please see the attached pictures below.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Tharikoppada,Reddy	Quality Assurance Inspector
----------------------	--------------------	-----------------------------

---

<b>Reviewed By:</b>	Miller,Mark	QA Reviewer
---------------------	-------------	-------------